

5/28/2018

LARGE FAB

[Dart Hawkesbury] Job Sheet - David, Logan

4306

SHIP

7-17

8-21

		Dart Aerospace Ltd. 1270 Aberdeen St Hawkesbury, ON K6A 1K7 Canada Tel (613) 632-5200		RBEM720V6000102-15 Job Sheet 178212 			
Part No: RBEM720V6000102-15 Part Name: Stiffener 		Job Qty: 16 ea Status: At Planning Priority: Medium					
Part Weight: 0 lbs Job Created: 5/28/18 Due Date: 6/18/18 Type: SOLD		Job Tracking No: Created By: Logan David Description:					
Note: DWG RBEM720V6000102 Rev. 2 IPP Rev. A 18.05.17 new issue DP Verify DD Ship Via:							
Bill of Materials							
Job Routing							
Op No	Operation	Qty	Start Date	Due Date	Standard Setup Run hrs hrs	Workcenter/Supplier Workcenter / Supplier Lead Time	Sign-off
90	Start up Operation	16 Ea	6/18/18	6/18/18	0.00 0.00	Start Up Small-Fab-2	
110	Large Fab	16 pcs	6/18/18	6/18/18	0.00 1.60	Large Fab 8	12 DAS
120	QC	16 pcs	6/18/18	6/18/18	0.00 0.00	QC5	38
130	Packaging	16 pcs	6/18/18	6/18/18	0.00 0.00	Packaging3-1	MLL 9-89
140	QC21-SA	16 Ea	6/18/18	6/18/18	0.00 0.00	QC21	
Part Op 110 - 1-Cut as per DWG. 2-Deburr. Descriptions:						DAS AUG 14 2018 21 9-89	
Job BOM							
Part / Item	Component Name	Quantity	Operation	Container			
88805K74	6063 Aluminum 90° Angle, 1/8" Wall Thickness, 1/2" High x 1/2" Wide	16 ft (1 ea)	90-Start up Operation	S015936			
Job Allocations							
Operation	Component Part	Required	Inventory	Allocated			
90-Start up Operation	88805K74	16	0	0			
Part Specifications							
Specifications could not be found.							

Plex 5/28/18 3:31 PM dart.logan.david

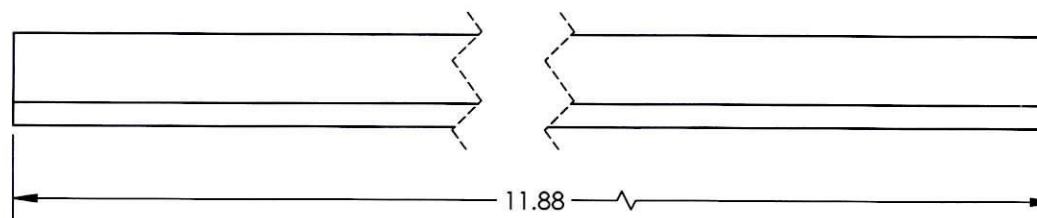
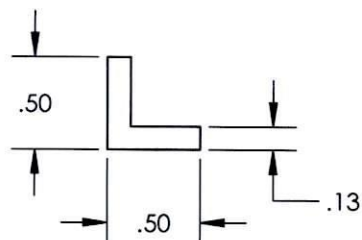
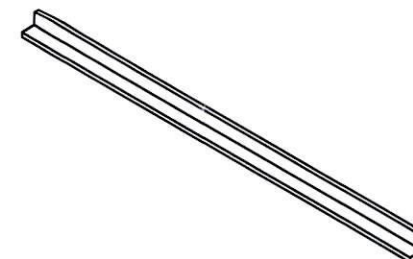
		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com	
Container No: S101312 			
Part: RBEM720V6000102-15 Job No: 178212 Serial No/Batch: S101312 Revision: 2 Inspector: Exp Date: Instructions:			
		Date: 08/13/18	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0217	-15 REDESIGNED TO BE WELDED. WAS FORMED IS ANGLE STOCK.	11/17/2016	RJC	JAG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 17822 ✓

20180712



(-15)

STIFFENER

DART AEROSPACE	
TITLE ENGINE BLANK	
DWG NO. RBEM720V6000102-15	REV 2
MAT'L 6063 HEAT TREAT FINISH SEE -1 SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125° ✓
DRAWN BY: CLOUGH CHECKED: DUERFELDT OPPS APPR: ANDERSON QA APPR: LINDSAY	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED: GILBERT	USED ON MODEL H175
SCALE 1:1	DATE 11/10/2016 SHEET 7 OF 9

178212

INSPECTION SHEET

[illegible]

Measured by:		Checked by:	38 9-89	QC Inspector:	
Date:		Date:	AUG 13 2018	Date:	

Engineering Approval: (if necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									